

Work Order ID 70420



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Tuesday, June 07, 2011 1:40:47 PM

Item ID: D4038-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/06/07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00



Bandsaw

Memo

0.00

11/06/08

10

Jeaspa Bandsaw

CUT BLANK 1.750" LONG

105

0.00



HAAS 1

Memo

0.00

CL 11/06/09 10

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA885

DWG REV:

FOLIO REV:

DEBURR

issue R10: 14260

Dan's Precision machine
as per dwg D 4038 REV. E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC need

Memo

0.00

Quality Control

need + inspect for transit damage
attached c/c to W10

PC/6/27 (P)

120

QC3 Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublet 30

(+9)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9 BK 11-7-11

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OK of M 4/6/04

160

Identify as per dwg & Stock Location: 114

0.00



Packaging

Memo

0.00

Packaging

11/7/11

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11
CL 11/6/10

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Picklist Print

Tuesday, June 07, 2011 1:40:45 PM

Page 1

Work Order ID: 70420

Parent Item: D4038-9

Parent Item Name: Block





Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased		No			f	24.7077		1.747368			
 													
6061-T6 Bar 1.50 x 2.00													

Location

Loc Qty

Loc Code

MAT010

24.70768

110167

0.65

114608

4.05768

117933

20

1.95 ~~7~~ 11/06/08

D 4038-9P

Rec'd 6/22/09

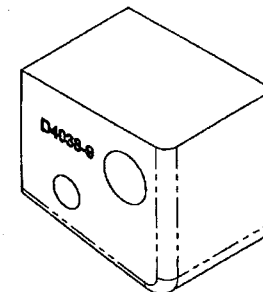
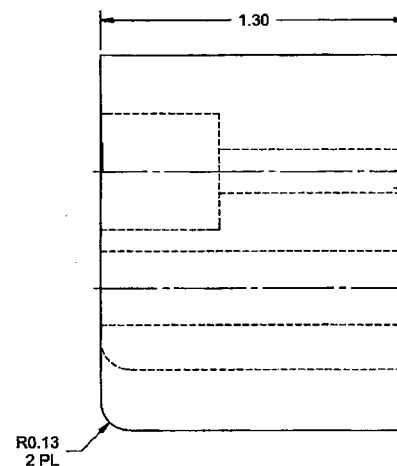
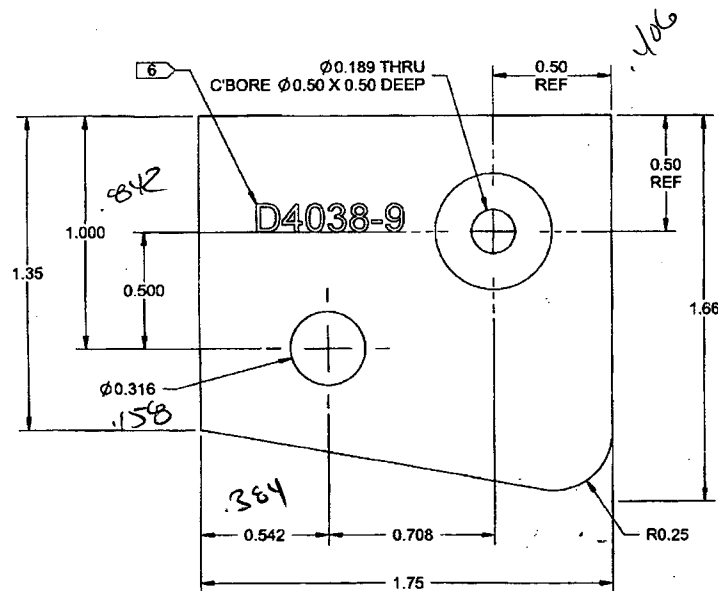
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CL11106107
W10: 70420

D4038-9 BLOCK

RELEASED
R 2011-04-21

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 11 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 27-Jun-11

Purchase Order : PO14260

Packing Slip : 10529

Part Number : D4038-9revE

Quantity : 9

811/6/30

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14260

W/O: _____

Part #: D4038-9 rev E

Bracket, Block

Qty: ~~10~~ 9

1 of 1